

Date: Thursday, 20/11/2008 3:12:02 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP STRUT		
Job Number	: 43576			Part Number	: D2017123		
Estimate Number	: 11938			Drawing Number	: D2017 REV E1		
P.O. Number	:			Project Number	: N/A		
This Issue	: 20/11/2008 S.O. No. :			Drawing Revision	: E1		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 28/12/2008 Qty: 4 Um: Each		
Previous Run	: 33205						
Written By	:						
Checked & Approved By	: JUL 08.11.21						
Comment	: Est D 02.06.19 Update processes (Ref. ECN 435) KJ/RF						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.1550 f(s)/Unit Total : 4.6200 f(s)

Punch tube type 304-2B,  $\frac{3}{4}$ " Ø. X .049" wall to length per Dwg. D2017 & spec control D2638

Batch No. M 110 271

SB 09/01/12

Deburr

FF 09/01/12  
M- 09/01/12

(4)

2.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/01/12 (4)

3.0	POWDER COATING	POWDER COATING
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m 109996

(4)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 1:55

OVEN TEMPERATURE: 400°

FINISH TIME: 2:25

FL 09/01/13

4.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

09-01-13 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:12:03 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP STRUT

Job Number: 43576

Part Number: D2017123

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 258

88 09/01/14 ④

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/15 88

Job Completion



200 09/01/14 ④

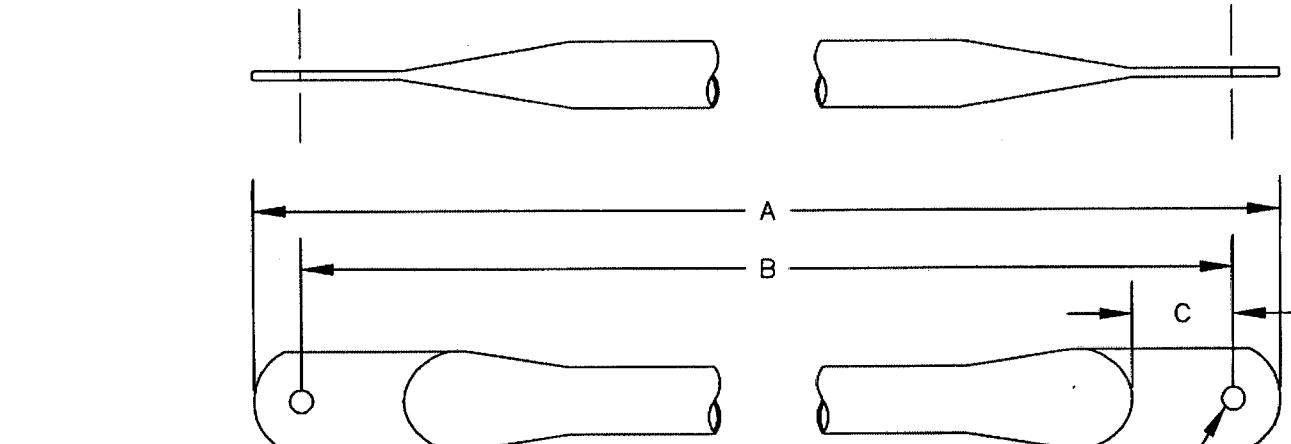
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

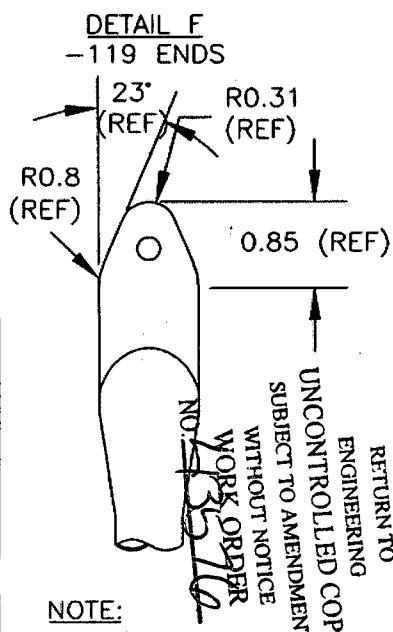
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)  
 "E" DIA TO BE OPENED MANUALLY (ONE END ONLY)



Part Number	A	B	C	D	E
D2017-101	17.73	16.93	1.30	0.250	0.312
D2017-103	18.74	17.94	1.30	0.250	0.312
D2017-105	14.95	14.15	1.30	0.250	-
D2017-107	15.61	14.81	1.30	0.250	-
D2017-109	13.93	13.13	1.30	0.250	-
D2017-111	15.30	14.50	1.30	0.250	-
D2017-113	20.50	19.70	1.30	0.250	0.312
D2017-115	12.42	11.62	1.30	0.250	-
D2017-117	13.86	13.06	1.30	0.250	-
D2017-119	26.75	25.95	1.30	0.250	-
D2017-121	12.30	11.50	1.30	0.250	-
D2017-123	12.92	12.12	1.30	0.250	-
D2017-125	19.55	18.75	1.30	0.250	-
D2017-127	20.30	19.50	1.30	0.250	-
D2017-129	31.43	30.63	1.30	0.250	-
D2017-131	19.68	18.88	1.30	0.250	-
D2017-133	30.66	29.86	1.13	0.250	-

NOTE:

FOR D2017-119: PUNCH PER D2638, GRIND ENDS PER DT8360 (SEE DETAIL F FOR REF.)  
 BEND FLARED ENDS 8° UP / 8° DOWN

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

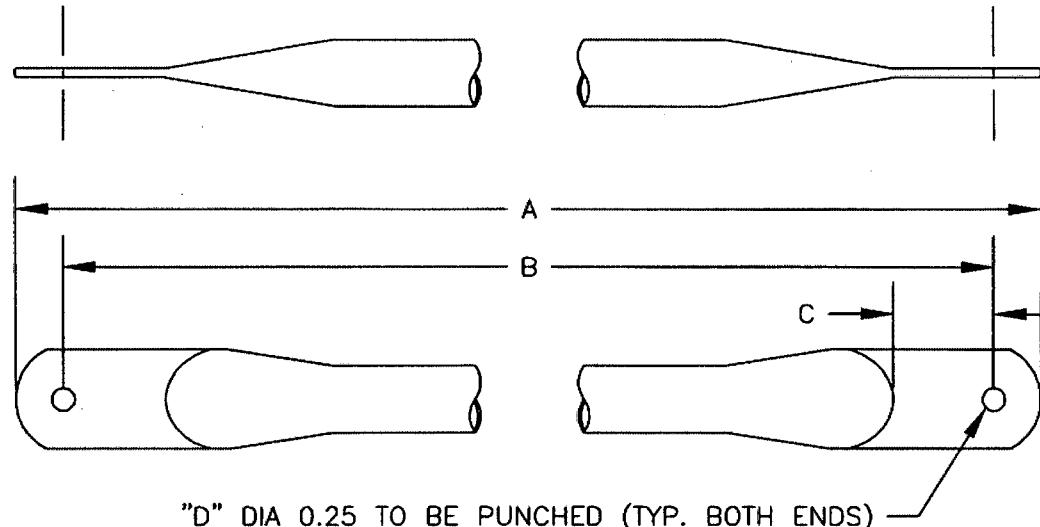
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.5 (E1)

**RELEASED**  
 99.05.11 KCE

**DART**

© DART  
DART

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED RE	APPROVED TH	DRAWING NO. D2017	REV. E	SHEET 1 OF 2
DATE 99.04.16		TITLE ENDS PUNCHED PER SPEC CTRL: -119 CHANGE (TSR A897)	SCALE N/A	
C	95.01.26	STEP STRUTS		
D	96.03.28	ADD PARTS		
E	99.04.16			
E1	02.03.22	ADD FINISH		



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)

Part Number	A	B	C	D
D2017-201	21.31	20.51	1.30	0.250
D2017-203	16.39	15.59	1.30	0.250
D2017-205	16.53	15.73	1.30	0.250
D2017-207	13.85	13.05	1.30	0.250
D2017-209	15.64	15.33	1.30	0.250
D2017-211	15.67	14.87	1.30	0.250
D2017-213	15.82	15.02	1.30	0.250
D2017-215	16.47	15.67	1.30	0.250
D2017-217	16.70	15.90	1.30	0.250
D2017-219	13.65	12.85	1.30	0.250
D2017-221	13.58	12.78	1.30	0.250
D2017-223	12.95	12.15	1.30	0.250
D2017-225	13.99	13.19	1.30	0.250
D2017-227	30.67	29.87	1.30	0.250

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WITHOUT NOTICE  
WORK ORDER  
No. 13516

**NOTE:**

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART Q51 005 4.3 /EA

RELEASED  
94-05411  
KE

**DART**



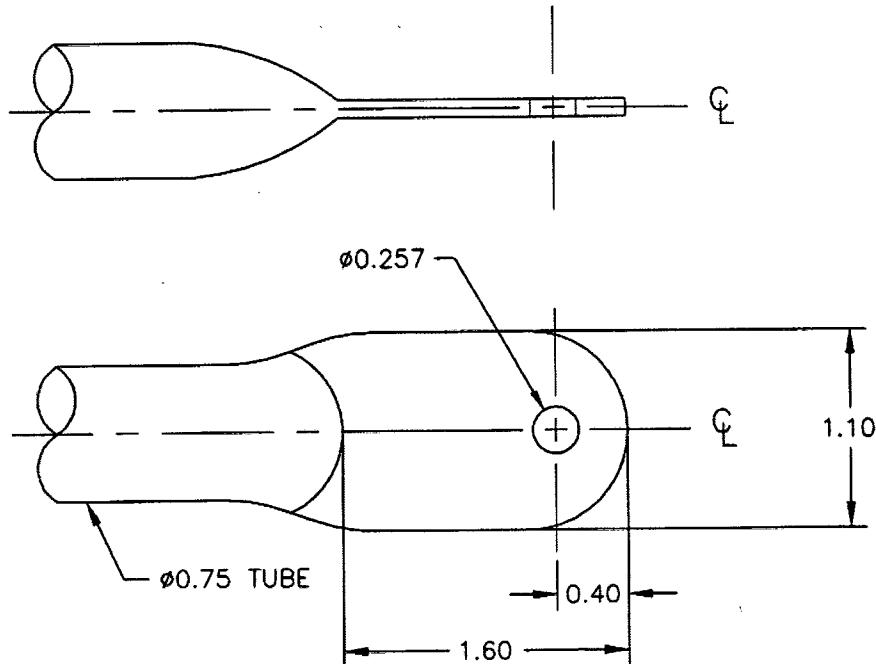
DESIGN	DRAWN BY <i>KF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
B/W	APPROVED <i>TM</i>	DRAWING NO. D2017	REV. E SHEET 2 OF 2
CHECKED <i>KE</i>	DATE 99.04.16	TITLE STEP STRUTS	SCALE NTS

**DART**COPY  
ONLY

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DAG	APPROVED J	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

**RELEASED**  
18/07/05 KE

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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